

Work Order ID 156485***156485***

Page 1

Friday, January 27, 2017 1:24:14 PM

Item ID: D4314-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 1/24/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: FEB 07 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4314	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg D4314 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

FEB 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				
Misidentified ☐	☐ Past Due					

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

COUNTER SINK AS PER DWG

0.00

0.01

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
36
9-89

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.01

DAS
38
9-89

FEB 21 2017

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.01

(X4)

2017/02/12
BEB

DQA: _____ Date: _____



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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

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Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.01

Quality Control

4

DAS
38
9-89

FEB 23 2017

180

Identify as per dwg & Stock Location: Ston

0.00

180

Packaging

Memo

0.01

Packaging

4

FEB 23 2017

DAS
6
9-89

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.07

Quality Control

DAS
21
9-89

FEB 23 2017

DAS
21
9-89 FEB 23 2017

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, January 27, 2017 1:24:13 PM

Work Order ID: 156485

156485

Parent Item: D4314-1

D4314-1

Parent Item Name: Shim

Start Date: 1/24/2017

Required Date: 1/27/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	55.9100	0.019	0.08			
M6061T6S 125									**				
6061-T6 .125 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		55.91							
				m135860		9.5							
				<u>m136327</u>		46.41							
											<u>0.083</u>		

DAS
46
9-89

17/02/19

DQA: _____ Date: _____

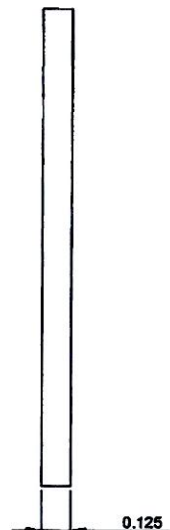
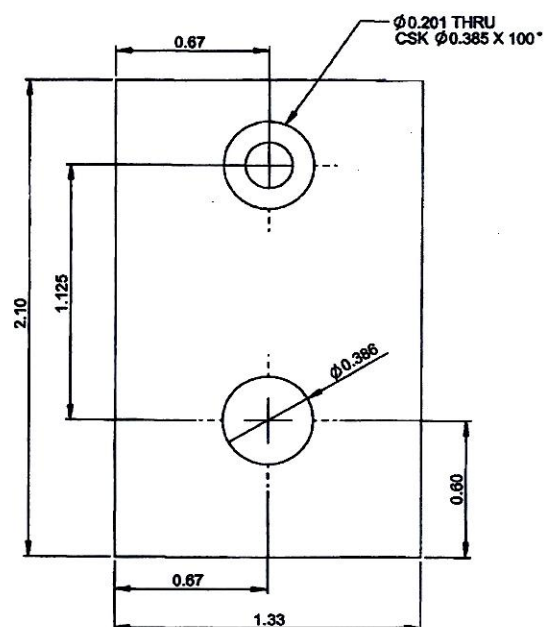
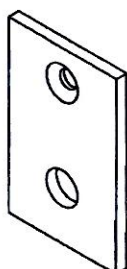


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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



D4314-1 SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156485 MLC
170202

RELEASED
2011-02-03
MB

- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE LTD		REV. A	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 2	
CHECKED	SC	DRAWING NO. D4314		SCALE NTS	
MFG. APPR.	SC	TITLE SHIM		DATE 11.01.13	
APPROVED	SC	COPYRIGHT © 2011 BY DART AEROSPACE LTD		THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF THE INFORMATION CONTAINED THEREIN IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD	
DE APPR.	SC				